

Date: Thursday, 11/23/2006 11:55:43 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STEP WELDMENT
Job Number	: 29669		
Estimate Number	: 10779		
P.O. Number	: <i>N/A</i>	Part Number	: D3463041
This Issue	: 11/23/2006 S.O. No. : <i>N/A</i>	Drawing Number	: D3463 REV.B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>N/A</i> Type : LARGE FAB ASSY	Drawing Revision	: A
Previous Run	: 28175	Material	: <i>N/A</i>
Written By	: <i>[Signature]</i>	Due Date	: 12/7/2006 Qty: 2 Um: EACH
Checked & Approved By	: <i>[Signature]</i> 06 11 23		
Comment	: EST REV. 05.11.18 new issue EC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	238806	SS DOWEL PIN 1" LONG
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	238-806	SS DOWEL PIN 1" LONG	<i>M19080</i>

*PD 07-01-04 (2)*

2.0	D34533	Clevis
-----	--------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3453-3	Clevis	<i>B28139 -&gt; 1</i> <i>B28211 -&gt; 1</i>

*PD 07-01-04 (2)*

3.0	D34637	Drag Arm
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3463-7	Drag Arm	<i>B28195</i>

*PD 07-01-04 (2)*

4.0	D34631	Arm
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3463-1	Arm	<i>B28213 -&gt; 1</i> <i>B28192 -&gt; 1</i>

*PD 07-01-04 (2)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Drawing Name: STEP WELDMENT

Job Number: 29669

Part Number: D3463041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D34633

Step



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch  
1 D3463-3 Step B2B193

PD

07-01-04 (2)

6.0

D34635F

End Cap



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch  
2 D3463-5F Step Flat Pattern B2B513

PD

07-01-04 (2)

7.0

D34535

Plug



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch  
1 D3453-5 Plug B2B212

PD

07-01-04 (2)

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld assembly as per dwg D3463 using DT8875

PD

07-01-04 (2)

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

11/07/08 (2)

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

11/07/08 (2)

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

1- Mask areas indicated on dwg D3463 (holes, threads)

2-Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

YK

07/01/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ ☐ Date: 07/01/12  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: STEP WELDMENT

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Part Number: D3463041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D3463 and QSI 005 4.4

*M103004*

*on 07/01/11 (2)*

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*W 07 01 11 (2)*

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

*EP 02/01/12 (2)*

*07/01/12 2*

15.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*(2) 07/01/12*

Job Completion



*U 07.01.12*

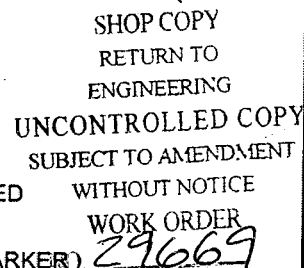
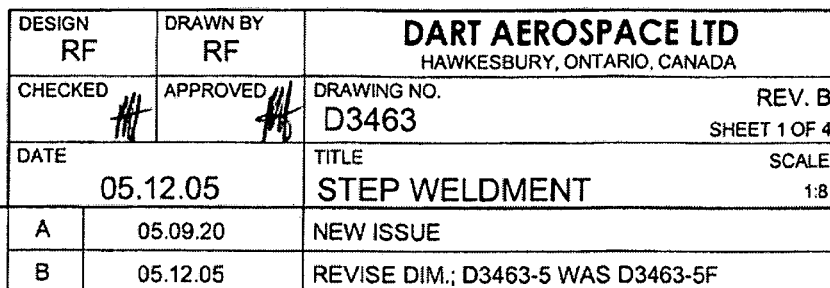
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_



NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

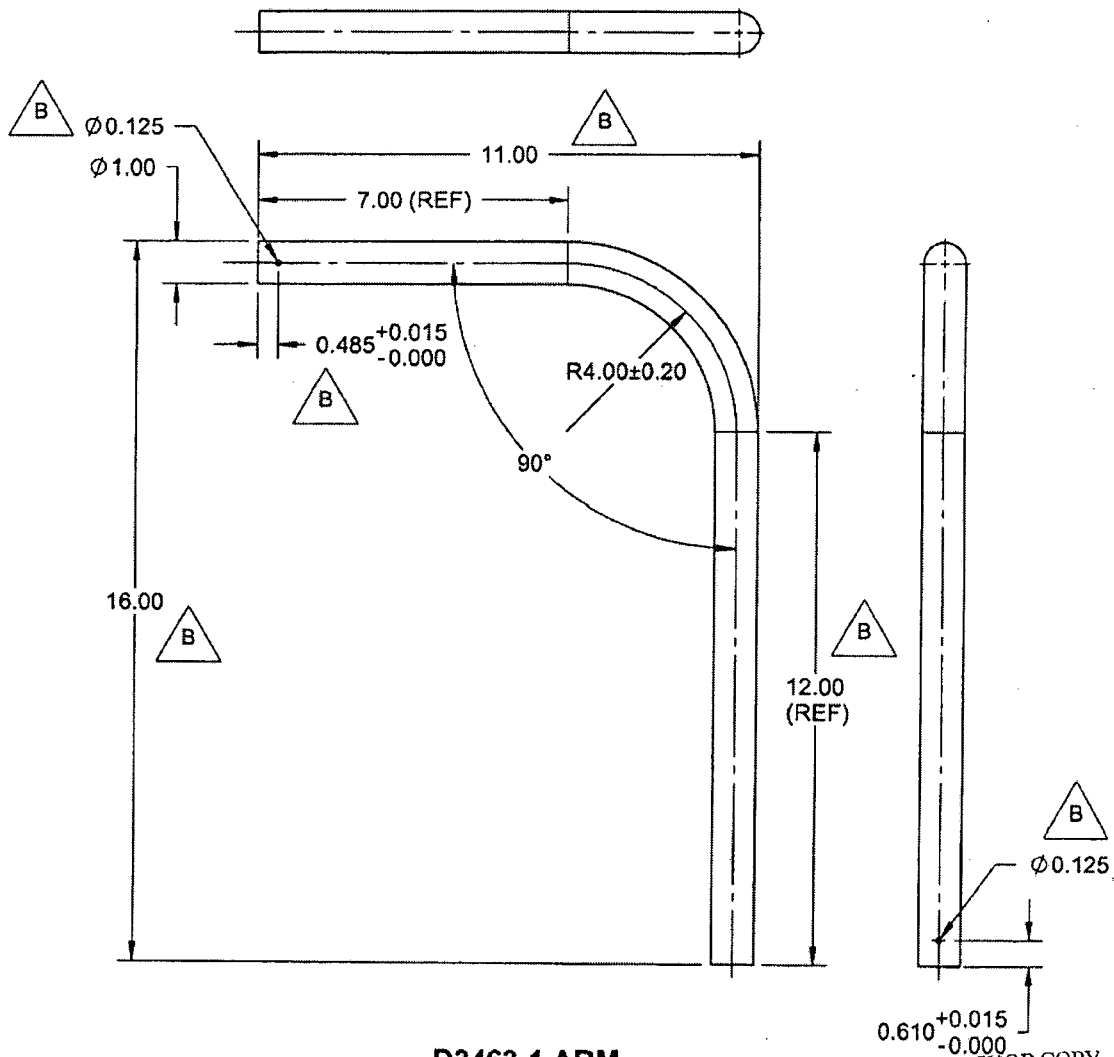

**NOTE:** Date & initial all entries



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**DART**

DESIGN RF	DRAWN BY RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. <b>D3463</b>	REV. B SHEET 2 OF 4
DATE <b>05.12.05</b>	TITLE <b>STEP WELDMENT</b>	SCALE 1:4	

**RELEASED**05.12.09 **D3463-1 ARM****NOTES:**

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC. M304TR1.000W-120)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.025

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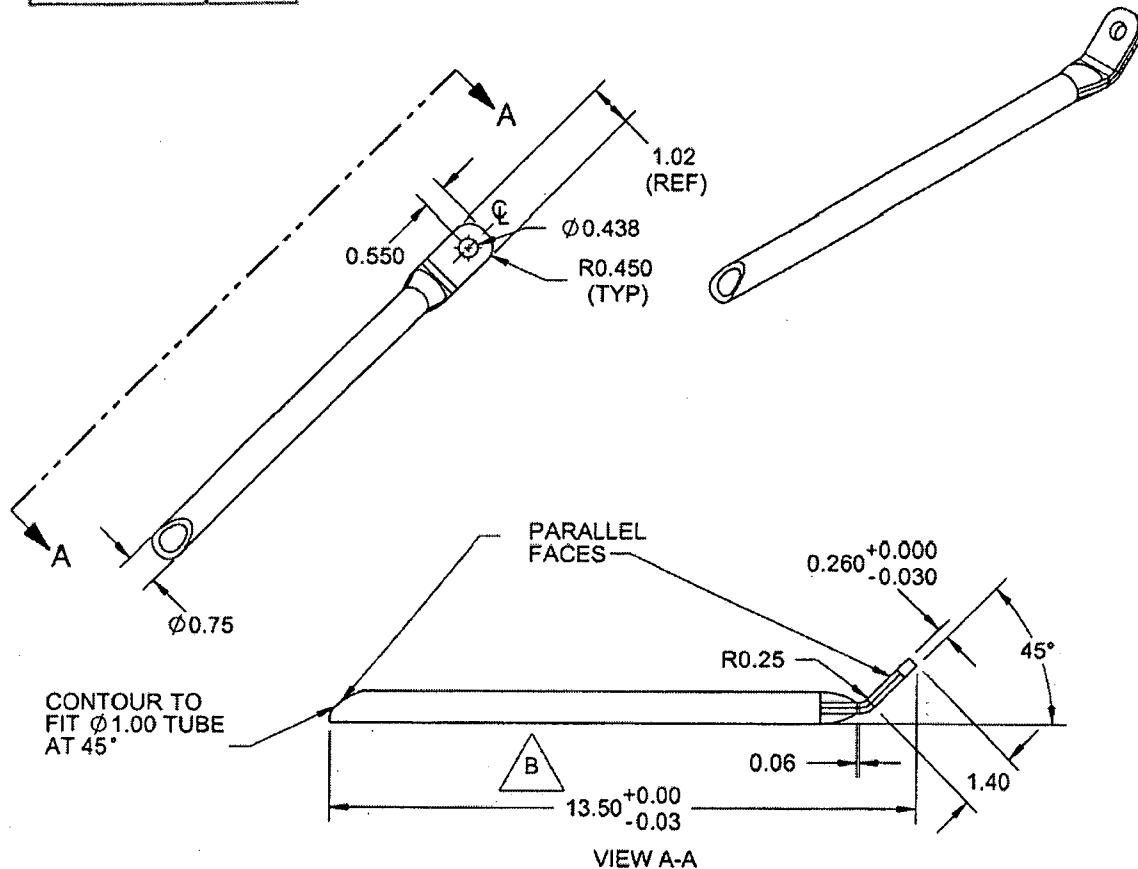


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CHECKED #	APPROVED #	DRAWING NO. <b>D3463</b>	REV. B SHEET 3 OF 4
DATE <b>05.12.05</b>	TITLE <b>STEP WELDMENT</b>		SCALE 1:4

**RELEASED**

05.12.09 #

**D3463-7 DRAG ARM****NOTES:**

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC. M304TR0.750W.120)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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